

A1 120 125W

Work Order ID 71607

Wednesday, July 06, 2011 1:30:30 PM



Item ID: D3204-1	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Tube					
Start Date: 7/6/2011	Start Qty: 8.00		Cust Item ID:		
Required Date: 7/20/2011	Req'd Qty: 8.00		Customer:		
Reference:					

Approvals:	Process Plan: <u>CL</u>	Date: <u>11/6/2013</u>	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3204	Rev A1

100		0.00							
	Hardinge CNC LATHE SMALL								
Hardinge	Memo	0.00							
Hardinge CNC Lathe Small	1-Turn tube as per Folio FA356 and Dwg D3204-2-Debur								

11/7/13

110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

11/7/13

120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

11-7-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71607

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Page 2

Item ID: D3204-1

Accept

Revision ID:

Item Name: Tube

Start Date: 7/6/2011 Start Qty: 8.00

Required Date: 7/20/2011 Req'd Qty: 8.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: WA 21 0.00

Packaging

Memo

0.00

Packaging

*****STOCK IN LARGE FAB*****

11-08-16

140

QC21 - Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

11/8/18

11-08-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, July 06, 2011 1:30:28 PM

Page 1

Work Order ID: 71607



Parent Item: D3204-1



Parent Item Name: Tube

Start Date: 7/6/2011

Required Date: 7/20/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP: ☐ B ☐ 04.06.09 ☐ Change Step 6; remove Steps 7 & 8 ☐ KJ/RF ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.750W.125		Purchased	No			100	f	14.9600	0.52	4.378947			
6061-T6 RD Tube .750 x .125W													

Location

MAT015

11409
117635

Loc Qty

14.96

~~2.96~~
12

Loc Code

* ~~2.96~~ Pt > 5.06
2.7 Pt

* 8.5 Pt scrap - end of bar

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

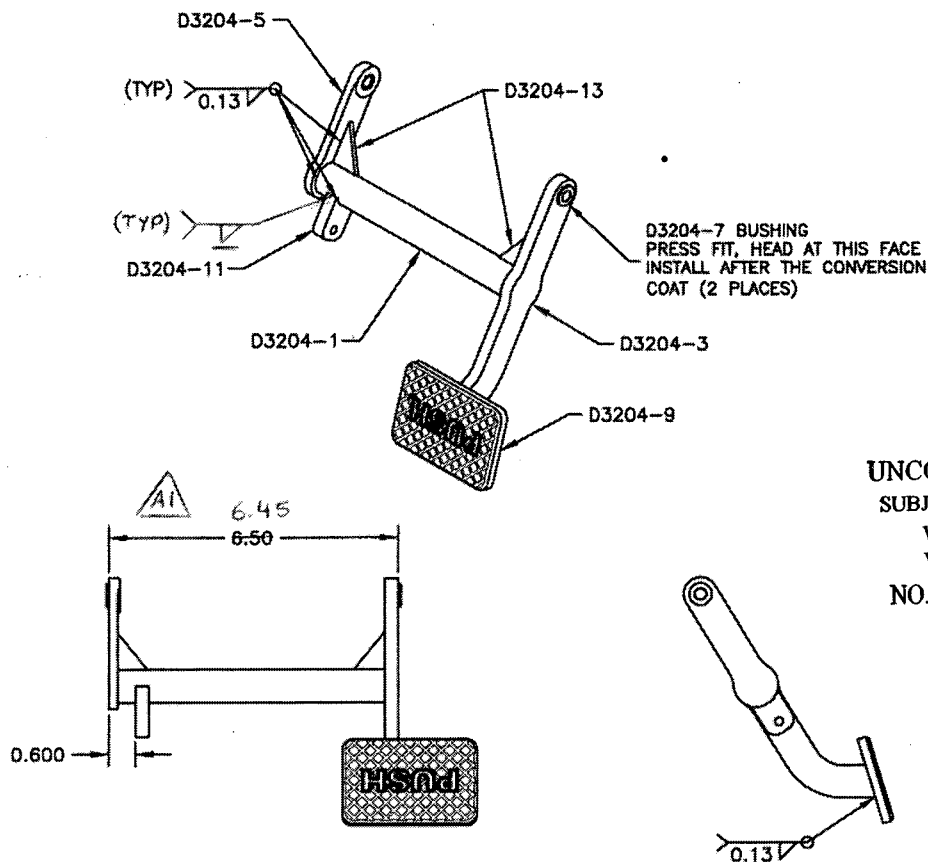
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3204	REV. A SHEET 1 OF 3
DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS
A	04.01.27	NEW ISSUE	
AI	05.07.15	6.45 WAS 6.50	

RELEASED
04.04.30



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NO. 71607
C21107106

D3204-041 RELEASE PEDAL ASSEMBLY

NOTES

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
- 6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020
ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
- 7) WELD ASSEMBLY PER QSI 004
- 8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 9) POWDER COAT ASSEMBLY GREY SANDTEX (REF. 4.3.5.6) PER QSI 005 4.3
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE INCHES

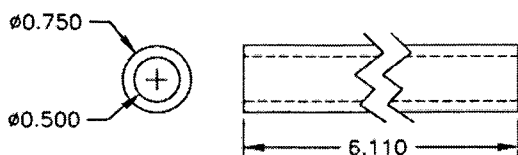
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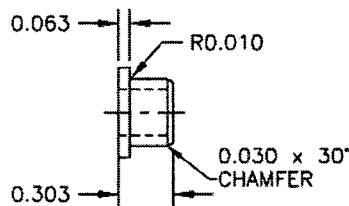


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DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS

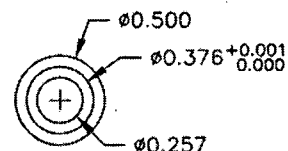
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2 D3204-1 TUBE
SCALE 1:2

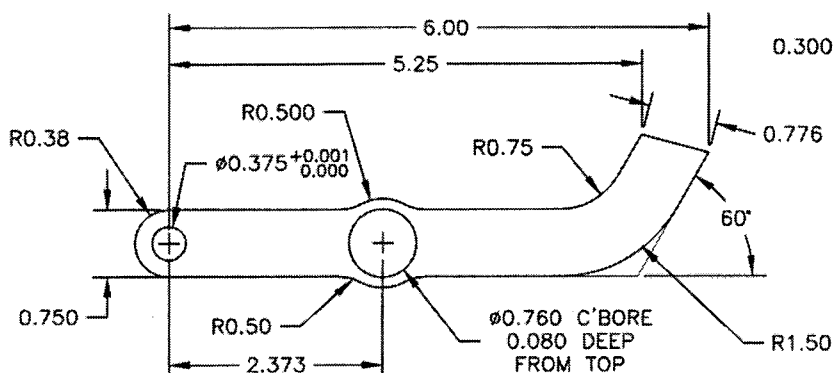


4 D3204-7 BUSHING
SCALE 1:1

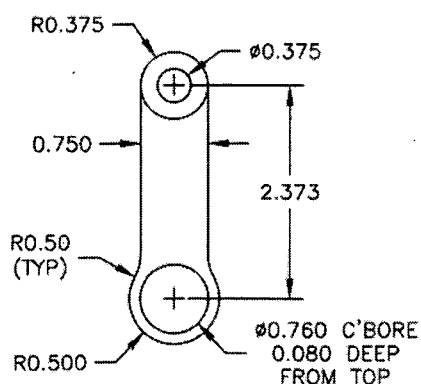
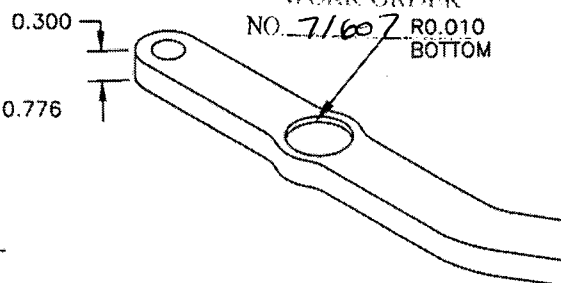


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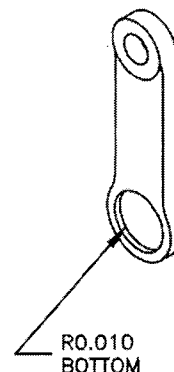
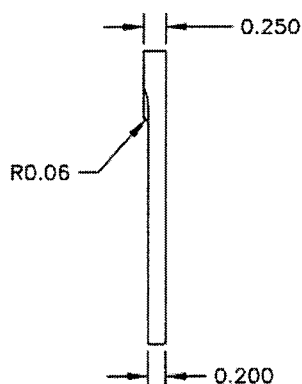
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3 D3204-3 ARM
SCALE 1:2



3 D3204-5 ARM
SCALE 1:2



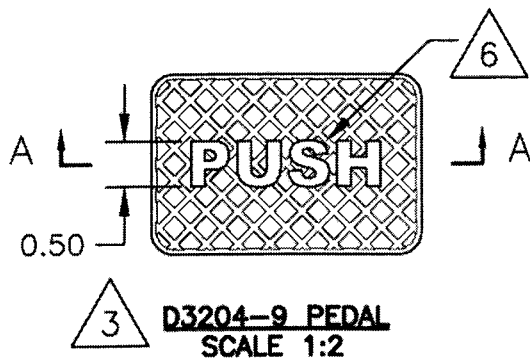
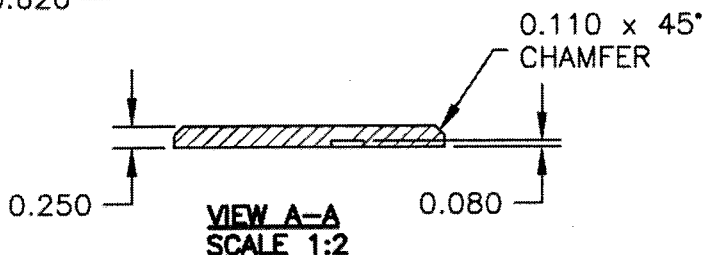
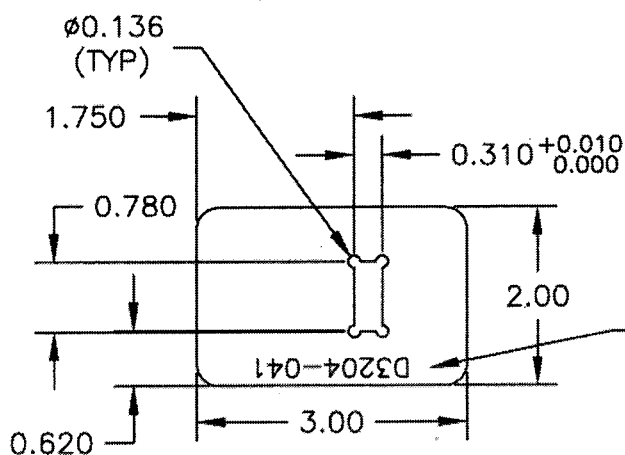
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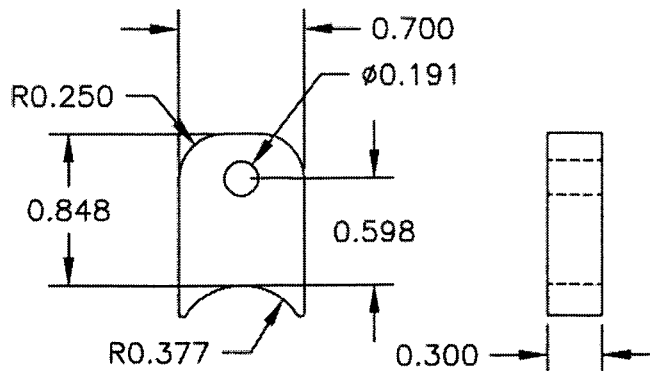


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DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS

RELEASED
04.04.70

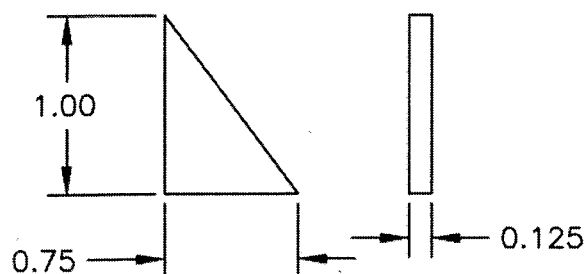


D3204-9 PEDAL
SCALE 1:2



D3204-11 PLATE
SCALE 1:1

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D3204-13 GUSSET
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